

Work Order ID 85841

June-15-12 1:36:08 PM

85841

Page 1

Item ID: D4154-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Plate

Start Date: 15/06/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 29/06/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/06/15 Tooling:

Date:

Run Start ***NR1***

QC: Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4154

D

100

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: DP

Prog Rev: DP

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

12-6-21

12-6-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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N900040100

Setup Start ***NS1***

Revision ID:

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Item Name: Plate

Start Date: 15/06/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 29/06/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Identify as per dwg & Stock Location: *W/E*

0.00

150

Packaging

Memo

0.00

Packaging

(X12) ME 12-07-03

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

12/7/4
ME
12-07-03

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Picklist Print

June-15-12 1:36:11 PM

Page 1

Work Order ID: 85841

85841

Parent Item: D4154-1

D4154-1

Parent Item Name: Plate

Start Date: 15/06/2012

Required Date: 29/06/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A 10.08.03 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA		Purchased	No			100	sf	163.3649	4.2697	53.93305			

M304S18GA

304/316 .050 Sheet

**

B12-6-31

Location

Loc Qty

Loc Code

MAT020

163.364947

120604

8.66421

121626

70.2

121660

84.500737

121 626

13

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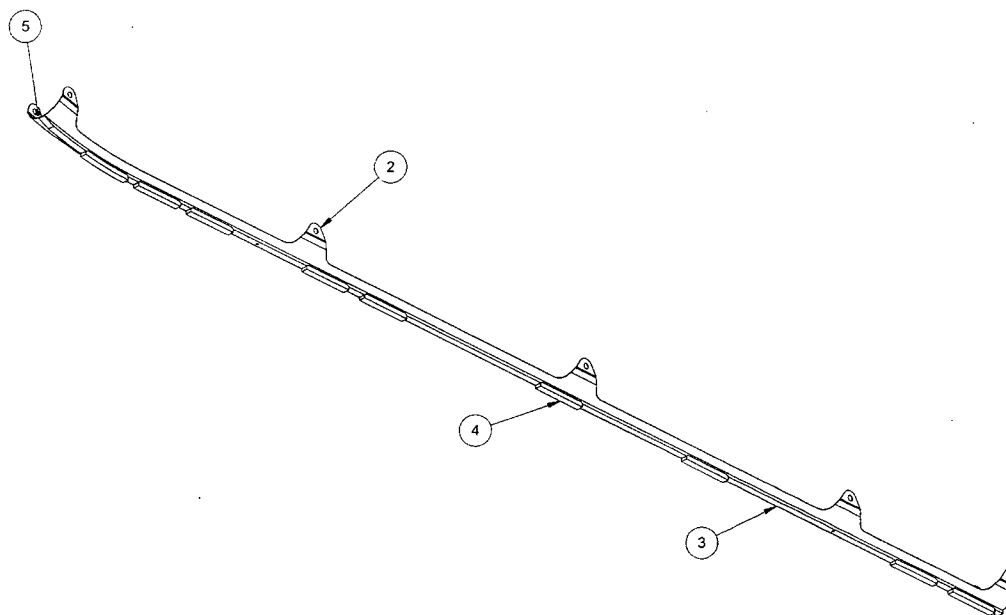
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ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
1	X	D4154-041	WEARPLATE ASSEMBLY
2	1	D4154-1	PLATE
3	1	D4155-1	BAR
4	A/R	2059B	HARDCOAT, (SEE NOTE 9, SHT 2)
5	A/R	4714	(SEE NOTE 11, SHT 2)



D4154-041 WEARPLATE ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 85841 MLJ
12/06/15

RELEASED
2012-05-09
MP

D	70.45 WAS 74.45 & Ø0.188 HOLES NOW 2 PL (ZN C4-3 & C7-3)	RF	12.05.03
C	REVISE NOTE 9 (ZN A8-2); ADD HARDCOAT (ZN B7-2); ADD DETAIL A (ZN C2-2)	RF	12.02.21
B	ITEM 4 WAS PR1422 (D3-1); REMOVED FINISH TO NOTE 2 (A8-2); REMOVED SECTION A-A (NO LONGER REQUIRED); REVISED D4154-1F	MB	11.04.05
A	NEW ISSUE	SC	10.07.22
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>[Signature]</i>	D4154	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	WEARPLATE ASSEMBLY	NTS
DATE	12.05.03	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

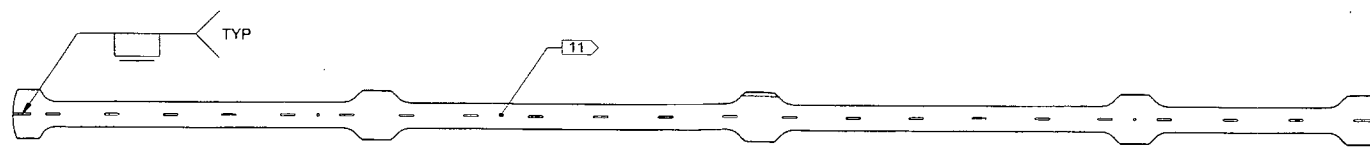
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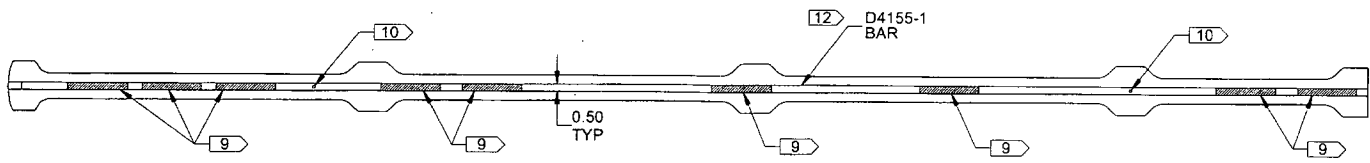
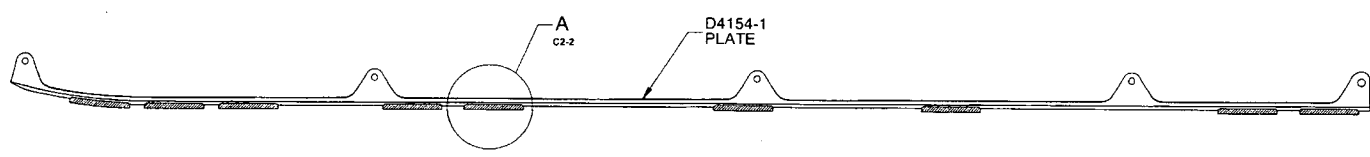
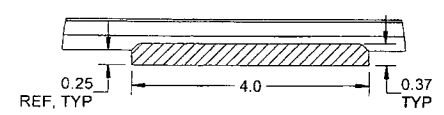
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NOTE: Date & initial all entries



25841



D4154-041 WEARPLATE ASSEMBLY

RELEASED
2012-05-09

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 6.88 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.37 THICK x 0.50 WIDE, FLUSH WITH D4155-1 BAR ON LATERAL SURFACES, 9 PL
- 10) TRANSFER DRILL Ø0.188 HOLES FROM D4154-1 PLATE TO D4155-1 BAR
- 11) COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER OF PLUS ONE ROCKGUARD 4714, 0.020-0.040 THICK
- 12) FORM TO-MATCH PROFILE OF D4154-1 AT TIME OF WELDING

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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>[Signature]</i>	D4154	SHEET 2 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	WEARPLATE ASSEMBLY	NTS
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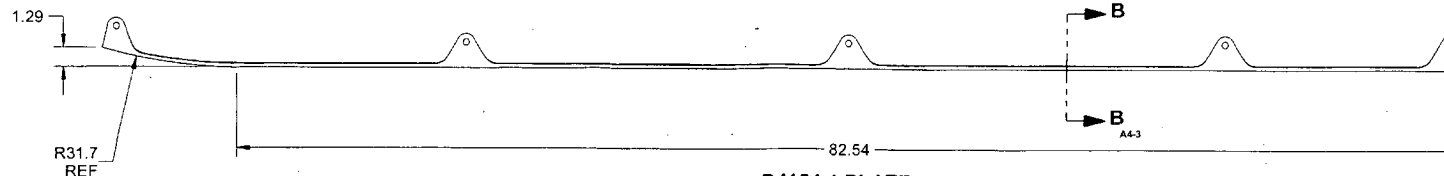
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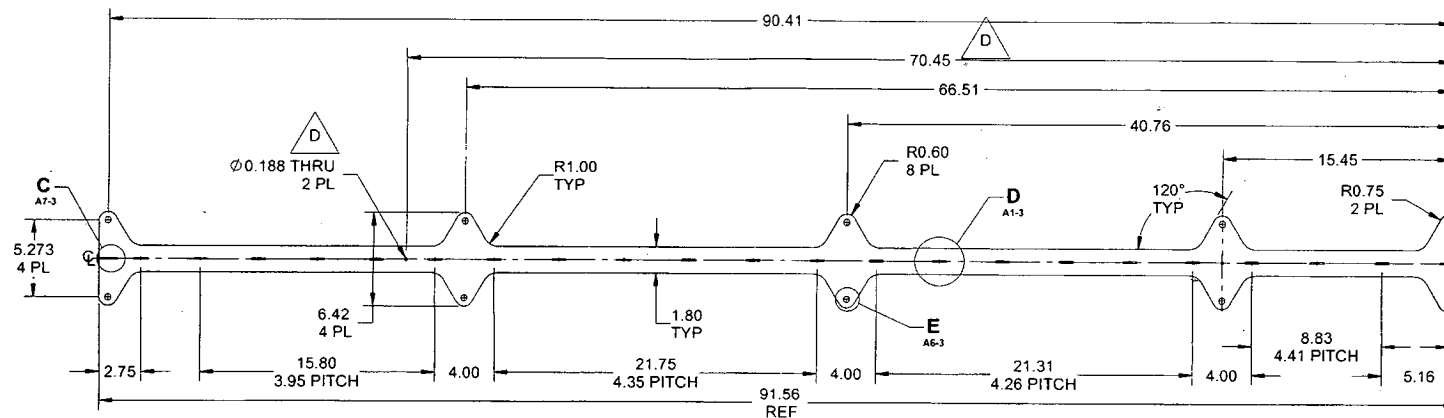
NOTE: Date & initial all entries



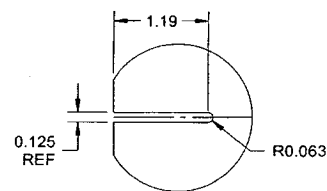
D4154-1 PLATE
(MAKE FROM D4154-1F)

85841

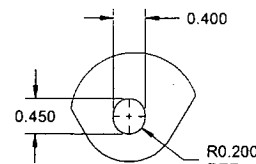
RELEASED
2012-05-09



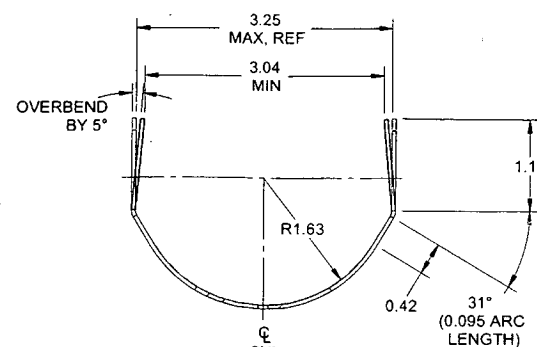
D4154-1F FLAT PATTERN



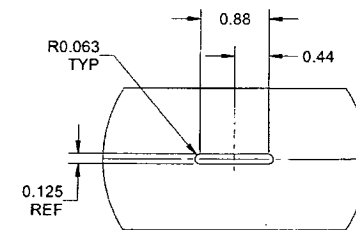
DETAIL C
END SLOT DETAIL, 2 PL C7-3



DETAIL E
SLOT DETAIL TYP C4-3



SECTION B-B D3-3



DETAIL D
SLOT DETAIL TYP C4-3

- NOTES:**
- 1) MATERIAL : AISI 304/316 STAINLESS STEEL PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240
18 GAUGE 0.050 THICK, (REF. DART SPEC. M304S18GA)
 - 2) FINISH : NONE
 - 3) TOLERANCES : PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS : INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES : 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION : NONE
 - 7) WEIGHT : 2.95-lbs

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DART AEROSPACE LTD		Work Order:	85841
Description: Plate		Part Number:	D4154-1
Inspection Dwg: D4154	Rev: D	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.400	+/-0.010	.400	L		V B2	
0.450	+/-0.010	.451	L		V	
0.125	+/-0.010	.126	L		V	
0.88	+/-0.030	.88	L		V	
1.19	+/-0.030	1.19	L		V	
5.273	+/-0.010	5.270	L		V	
2.75	+/-0.030	2.75	L		V	
15.80	+/-0.030	15.80	L		T B2	
3.95	+/-0.030	3.954	L		V	
4.00	+/-0.030	4.003	L		V	
6.42	+/-0.030	6.422	L		V	
21.75	+/-0.030	21.75	L		T	
4.35	+/-0.030	4.352	L		V	
1.80	+/-0.030	1.809	L		V	
21.31	+/-0.030	21.31	L		T	
4.26	+/-0.030	4.258	L		V	
8.83	+/-0.030	8.83	L		P	
5.16	+/-0.030	5.161	L		V	
0.55	+/-0.030	.549	L		V	
91.56	+/-0.030	91.56	L		T	
90.41	+/-0.030	90.41	L		T	
70.45	+/-0.030	70.45	L		T	
66.51	+/-0.030	66.51	L		T	
48.59	+/-0.030	48.59	L		T	
40.76	+/-0.030	40.76	L		T	
15.45	+/-0.030	15.45	L		T	
5.223	+/-0.010	5.224	L		T	
Ø0.516	+0.008/-0.001	.518	L		V	
Ø0.188	+0.005/-0.001	.188	L		V	
0.050	+/-0.010	.0577	L		V	

Measured by:	R
Date:	12-6-21

Audited by:	M/Z
Date:	12.6.22

Preliminary Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A	10.09.23	New Issue	KJ	
B	11.04.28	Dimensions updated per Dwg Rev B	KJ	
C	12.05.24	Dimensions updated per Dwg Rev C	KJ	

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